

Work Order ID 81948

81948

Page 1

March-21-12 11:55:40 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 21/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/21

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

JB Schulzo

MLJ 12-4-20

B819 4/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

B 12/04/03

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: <i>M20164 BE 12/04/03</i>								
	12-Grind welds flush as per Dwg D2750 <i>-> CF 12-4-4</i>								
120 *120* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				<i>1</i>	<i>0</i>		
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<i>12-4-4</i>

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

Handwritten notes and signatures:
 12-04-04
 BE12/04/04

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: M120613

exp. date: 12-08-13

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod

batch: M120164

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

B/est 12-04-04

36 12-04-10

B/HG/12-4-10

D/CC 12/04/11

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Reference:

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

Accept Qty

Reject Qty

Reject Number

**Insp.
Stamp**

dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>4:00</u> OVEN TEMPERATURE: <u>320 °F</u> FINISH TIME: <u>4:30</u>								
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

1X ϕ

m-l
12/04/11

1X ϕ

m-l
12/04/11

1R+1 ϕ

Ill n/04/16

ml 20222

W/O:		WORK ORDER CHANGES					
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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00

230

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

✓ 1-Install inserts as per dwg D2750

✓ 2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"

batch: U1A

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11121221

EXP DATE: 13102

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 11110348

6-Coat all exposed fasteners with "LPS Procyon"

batch: 1114596

1RH 1 11/12/04/16

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
240		0.00							
QC	Memo								
Quality Control									
250	Pick Kit	0.00							
250		0.00							
Packaging	Memo								
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260		0.00							
QC	Memo								
Quality Control									

8/7/4/19

1

12/04/20 AB

8/2/4/20

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging	0.00	Rev	I					12/4/23
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280		0.00							
280	QC21- Final Inspection - Work Order Release	0.00							12/4/23
QC	Memo	0.00							
Quality Control									

12-04-20

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Picklist Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	18.0000	1				
D2600-3-BENT									**				
Extrusion Bent													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG	18								
				66875	7								
				73253	1								
				75021	1								
				75022	1								
				75023	1								
				81330	7								
D2744		Manufactured	No			110	Each	56.0000	1				
D2744									**				
Cap													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG002	56								
				62715	1								
				70881	9								
				71861	4								
				78900	42								

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Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

6.0000

1

1

D2739

350 I Beam

B 82122

**

Ⓢ

12-04-04

Location

Loc Qty

Loc Code

LG

6

72155

1

80083

5

D2743

Manufactured No

160

Each

216.0000

8

8

D2743

Crossbolt Spacer

**

BE 12/04/10

Location

Loc Qty

Loc Code

LG001

216

67766

4

68251

3

73403

64

74445

1

78603

44

79517

100

8

D3490-3

Manufactured No

160

Each

22.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE 12/04/10
B 82016 14

Location

Loc Qty

Loc Code

LG001

22

78800

22

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Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

33.0000

4

4

D3490-1

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG001

33

62450

2

74875

4

77042

3

78793

24

BE 12/04/10
B81976 x4

D3631-1

Manufactured No

230

Each

191.0000

8

8

D3631-1

Washer

**

Location

Loc Qty

Loc Code

ST072

191

68062

2

75548

189

X 0
1

D3791-1

Manufactured No

230

Each

15.0000

1

1

D3791-1

Wearplate

**

Location

Loc Qty

Loc Code

FP002

15

62239

2

75041

1

78897

12

X 1

W/O:		WORK ORDER CHANGES					
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Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

24.0000

1

1

D3793-3

Wearshoe

**

Handwritten: 12/04/16

Location

Loc Qty

Loc Code

FP001

12

80434

12

FP002

12

78935

12

MS21043-6

Purchased No

230

Each

797.0000

4

4

MS21043-6

NUT

**

Handwritten: 12/04/16

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

777

112314

71

117887

6

118384

200

120308

500

D3794-1

Manufactured No

230

Each

22.0000

1

1

D3794-1

Gasket

**

Handwritten: 12/04/16

Location

Loc Qty

Loc Code

FP002

22

75042

10

80435

12

Handwritten: X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

March-21-12 11:55:44 AM

Work Order ID: 81948

81948

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

185.0000

8

8

NAS1611-010

O-RING

**

ML 12/04/16

Location

Loc Qty

Loc Code

FP

50

110915

0

120770

50

Y8

FP001

135

110915

14

117460

8

118077

1

118612

3

119438

47

120308

12

120986

50

D2741

Manufactured

No

250

Each

33.0000

1

1

D2741

Blade, 350 Skidtube

**

JB 12/04/20

Location

Loc Qty

Loc Code

ST

-10

ST466

43

71856

1

76984

32

76984

March-21-12 11:55:44 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

March-21-12 11:55:44 AM

Work Order ID: 81948

81948

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

172.0000

4

4

***NAS1515H3I ***

WASHER

**

92

12/04/12

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

132

118686

3

119438

1

120072

32

120360

96

X4

NAS1611-013

Purchased

No

230

Each

144.0000

8

8

NAS1611-013

O-RING

**

92

12/04/12

Location

Loc Qty

Loc Code

FP001

144

116582

5

117291

2

117887

53

119623

36

120910

48

X8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 11:55:44 AM

Work Order ID: 81948

81948

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

571.0000

4

4

AN3C6A

BOLT

**

HL 12/04/16

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

570

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

81

120693

400

X4

NAS1149C0832R

Purchased

No

230

Each

301.0000

1

1

NAS1149C0832R

WASHER

**

HL 12/04/16

Location

Loc Qty

Loc Code

ST297

301

114915

301

X1

D3536-25

Manufactured

No

230

Each

14.0000

1

1

D3536-25

Gasket

**

HL 12/04/16

Location

Loc Qty

Loc Code

FP002

14

78902

14

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

March-21-12 11:55:44 AM

Work Order ID: 81948

81948

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

29.0000

1

1

D3794-3

Gasket

**

HL 12/04/12

Location

Loc Qty

Loc Code

FP002

29

74530

2

78895

3

80436

24

X1

AN3C5A

Purchased No

230

Each

1,338.000

34

34

AN3C5A

Bolt

**

HL 12/04/12

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1331

116419

28

117343

13

117764

7

117872

2

119749

23

120423

758

X34

1210168

500

D3537-1

Manufactured No

230

Each

105.0000

3

3

D3537-1

Wearpad

**

HL 12/04/12

Location

Loc Qty

Loc Code

FP001

100

79833

46

79835

54

FP002

5

69817

5

1373716

X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

March-21-12 11:55:44 AM

Work Order ID: 81948

81948

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

17.0000

1

1

D3535-25

Wearshoe

**

ul 12/04/16

Location

Loc Qty

Loc Code

FP001

14

62233

1

80331

13

FP002

3

77617

3

D3492-3

Manufactured No

230

Each

45.0000

8

8

D3492-3

Plug

**

ul 12/04/16

Location

Loc Qty

Loc Code

FP-A

45

78600

45

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38

*AN960C10L *

washer

M121255**

(38) ul 12/04/16

D3488-042

Manufactured No

230

Each

18.0000

1

1

D3488-042

Blade Fitting Assembly, RH

**

ul 12/04/16

Location

Loc Qty

Loc Code

FP002

18

62003

1

75068

9

77015

8

ul

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

March-21-12 11:55:44 AM

Work Order ID: 81948

81948

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

980.0000

38

38

AI S4-1032-225

21/04/12

Insert

Location

Loc Qty

Loc Code

ST281

947

1121269

✓38

108696

146

110768

62

118386

55

118966

68

120671

616

ST282

33

120410

20

120451

13

D3492-1

Manufactured

No

230

Each

106.0000

8

8

D3492-1

21/04/12

Plug

Location

Loc Qty

Loc Code

FP002

106

69531

8

74444

2

76235

4

77037

92

1381963

×8

D3793-1

Manufactured

No

230

Each

16.0000

1

1

D3793-1

21/04/12

Wearshoe

Location

Loc Qty

Loc Code

FP001

16

77029

4

78901

12

×1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 11:55:44 AM

Work Order ID: 81948

81948

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

62.0000

1

1

AN8C35A

BOLT

**

ME 12/04/16

Location

Loc Qty

Loc Code

FP002

61

115960

1

117834

8

118286

52

ST346

1

114442

0

115188

0

115960

1

X1

MS21083C8

Purchased

No

230

Each

79.0000

1

1

MS21083C8

NUT

**

ME 12/04/16

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

12

115884

0

118077

1

119309

2

119436

7

119638

2

ST304

66

120142

16

120731

25

121011

25

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

March-21-12 11:55:44 AM

Work Order ID: 81948

81948

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

112.0000

8

8

D2745

Bushing

**

(8) 2/11

12/04/14

Location

Loc Qty

Loc Code

FP

100

1381964

✓ 2

79518

100

✓ 6

FP001

12

69529

1

76142

1

78597

10

AN6C44A

Purchased No

230

Each

95.0000

4

4

AN6C44A

BOLT

**

2/11 12/04/14

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

93

120143

25

120465

27

120641

21

121013

20

✓ 4

D3532-1

Manufactured No

250

Each

39.0000

2

2

D3532-1

Spacer

**

2/11 12/04/20

Location

Loc Qty

Loc Code

ST053

39

78839

39

78839

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 13

March-21-12 11:55:44 AM

Work Order ID: 81948

81948

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

79.0000

2

2

**

MS21083C8

NUT

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

12

115884

0

118077

1

119309

2

119436

7

119638

2

ST304

66

120142

16

120731

25

121011

25

121011

NAS1149D0863J

Purchased

No

250

Each

227.0000

2

2

**

NAS1149D0863J

WASHER

Location

Loc Qty

Loc Code

ST298

227

118078

36

119307

91

120308

100

119307

D3493-1

Manufactured

No

250

Each

62.0000

2

2

**

D3493-1

Washer

Location

Loc Qty

Loc Code

ST050

62

70697

2

77573

20

78835

40

78835

March-21-12 11:55:44 AM

Shop Packet Print

Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 14

March-21-12 11:55:44 AM

Work Order ID: 81948

81948

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

67.0000

2

2

**

g B 12/04/20

AN8C21A

BOLT

Location

Loc Qty

Loc Code

ST343

67

118758

5

120094

38

120872

4

121067

20

120094

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81948 MJS

12/03/21

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO.

D2750

REV. F

SHEET 1 OF 11

TITLE

350 SKIDTUBE ASSEMBLY

SCALE

NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

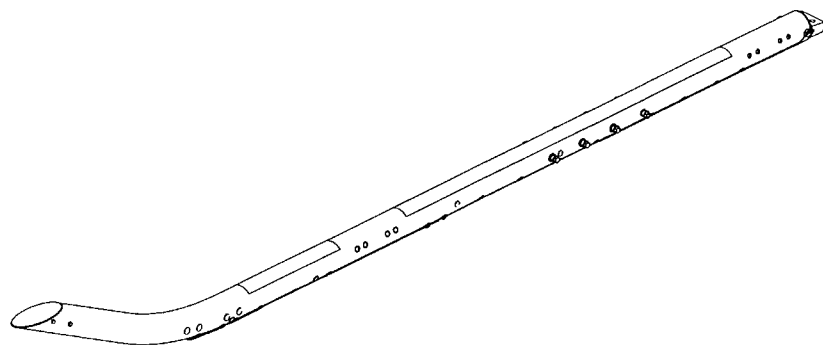
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

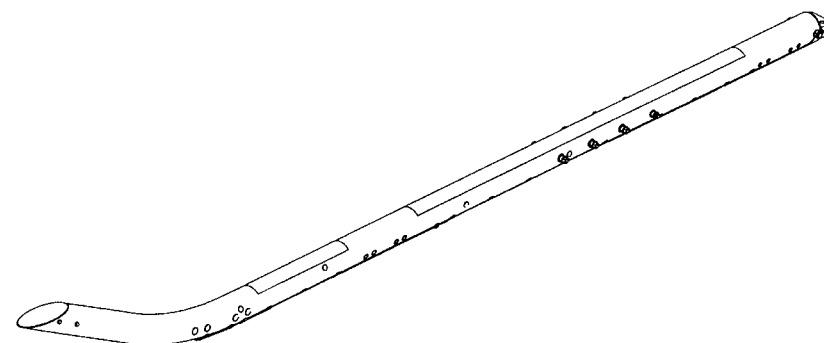
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81948



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
28-9-22/11

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	AD	PORT HADLOCK, WA	
CHECKED	AD	DRAWING NO. D2750	REV. F
MFG. APPR.	AD	SHEET 2 OF 11	
APPROVED	ME	TITLE	SCALE
DE APPR.	AD	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

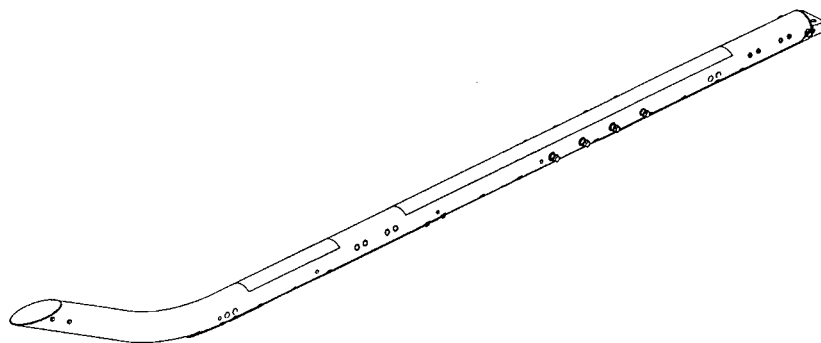
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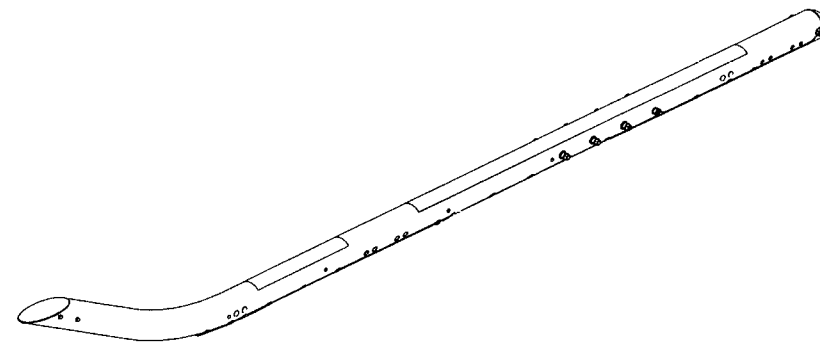
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81948



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
68-09-22/100

DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	LP	PORT HADLOCK, WA	
CHECKED	MA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 3 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

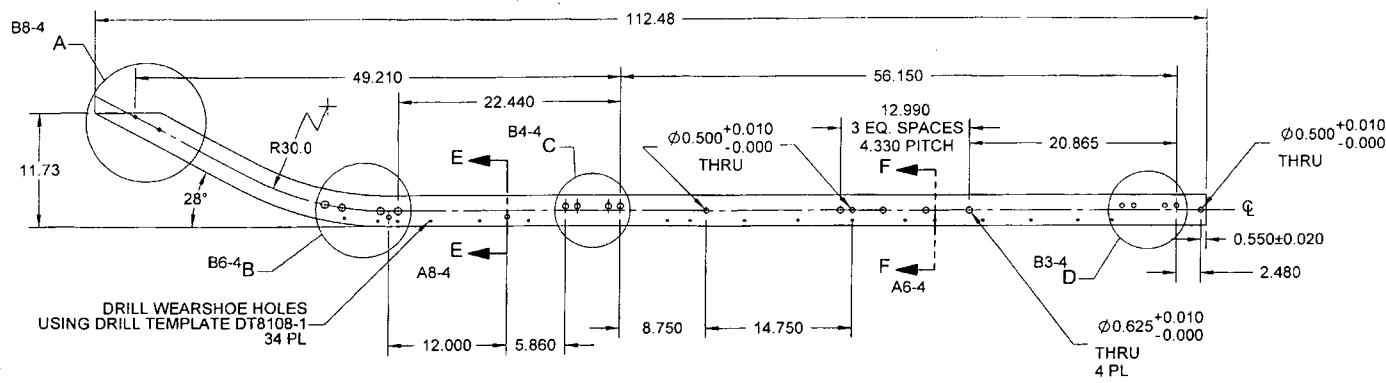
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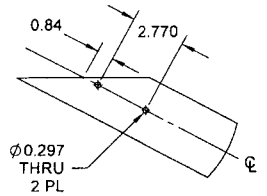
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

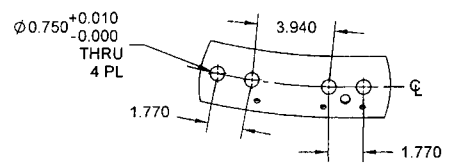
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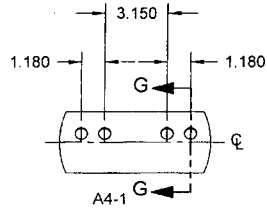
D2750-1 LH SKIDTUBE



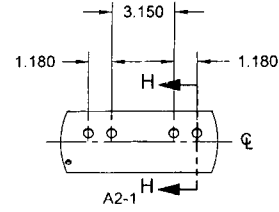
DETAIL A
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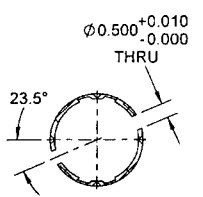
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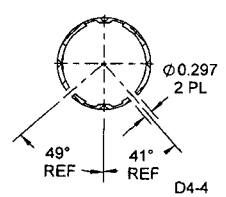
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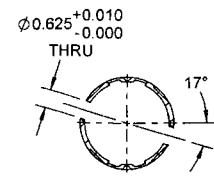
DETAIL D
SCALE 2X



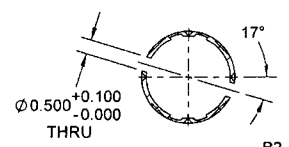
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

RELEASED

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

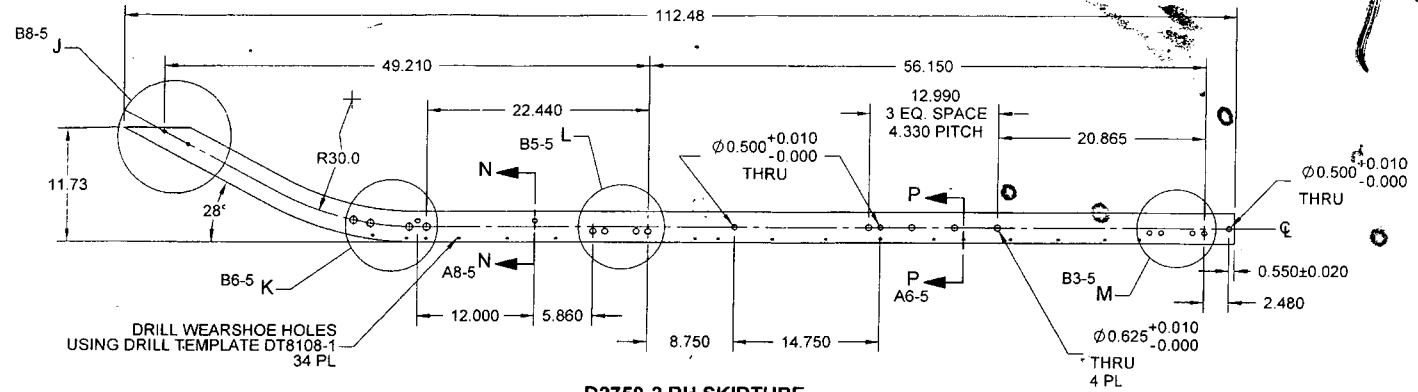
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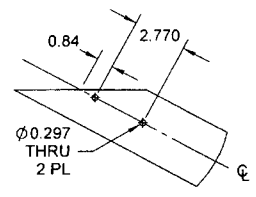
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

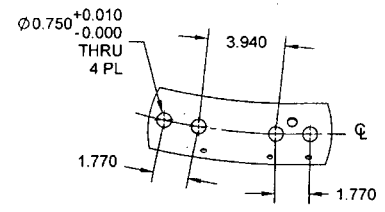
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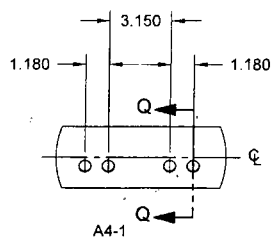
D2750-2 RH SKIDTUBE



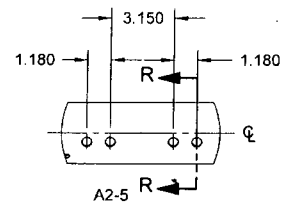
DETAIL J
SCALE 2X



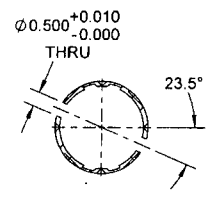
DETAIL K
SCALE 2X



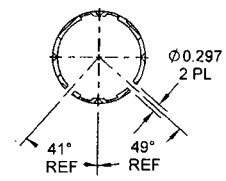
DETAIL L
SCALE 2X



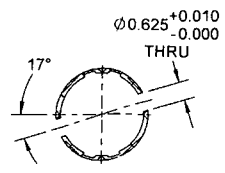
DETAIL M
SCALE 2X



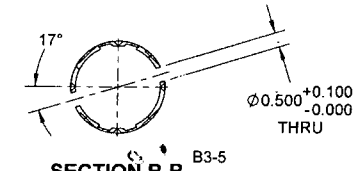
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

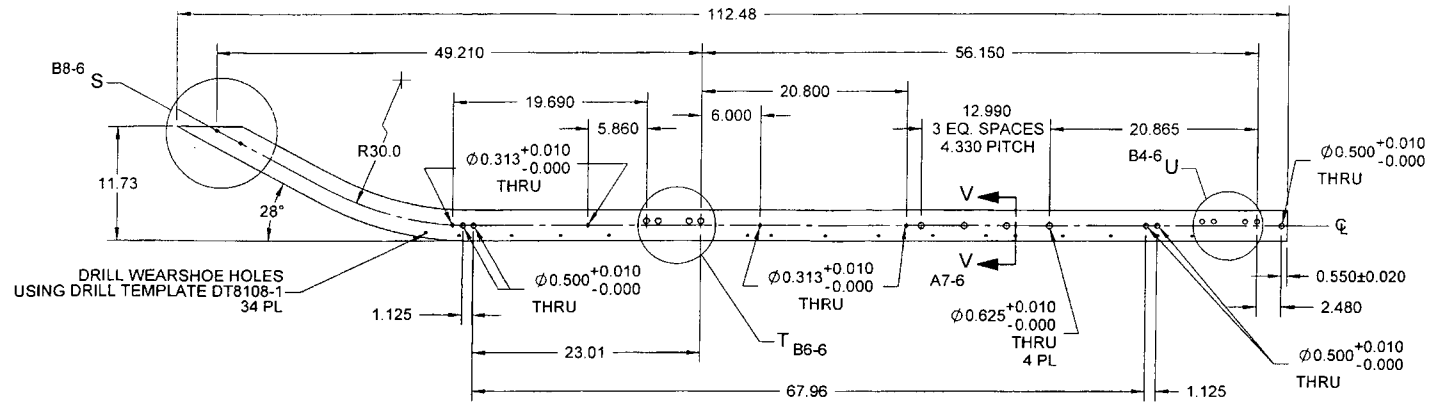
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

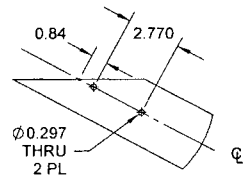
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

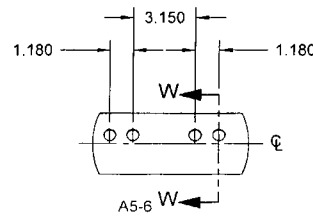
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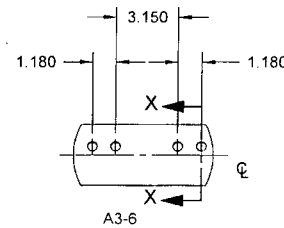
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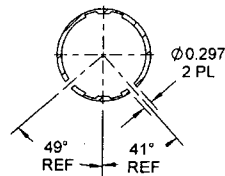
DETAIL S
SCALE 2X



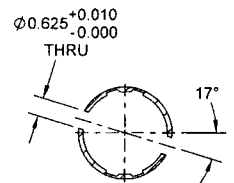
DETAIL T
SCALE 2X



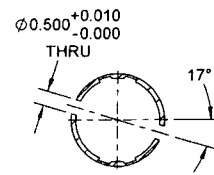
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

RELEASED

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE	SCALE
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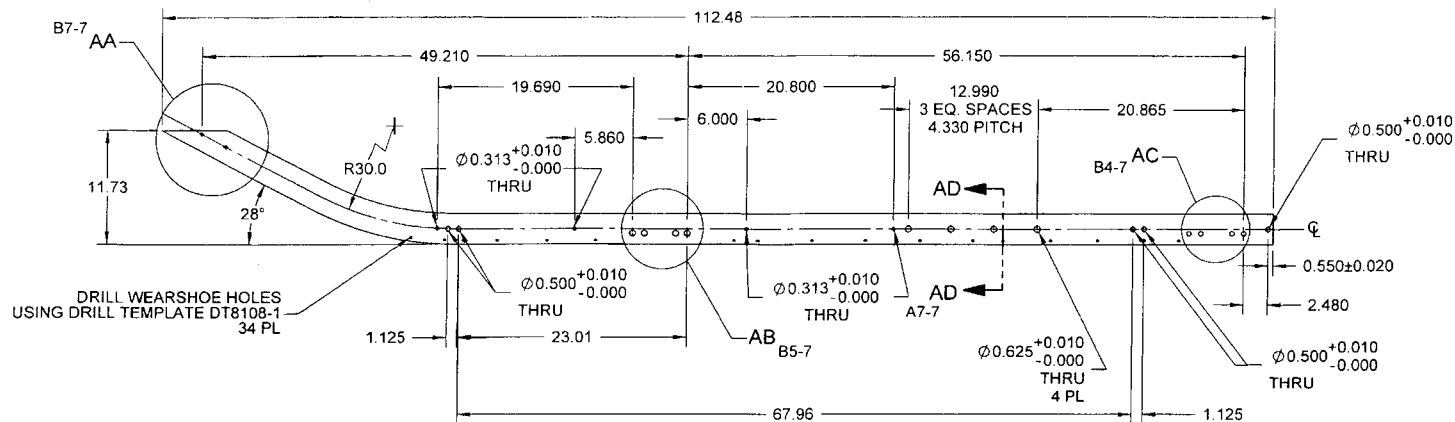
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

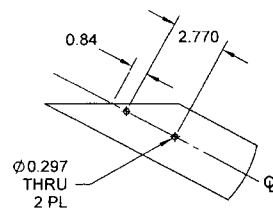
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

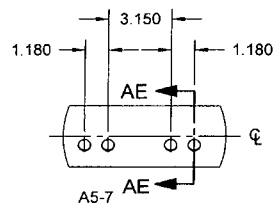
NOTE: Date & initial all entries



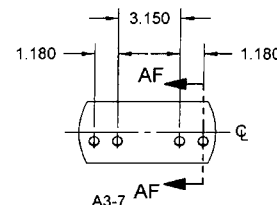
D2750-4 RH SKIDTUBE



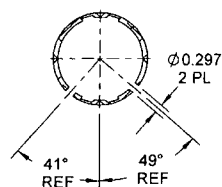
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D7-7



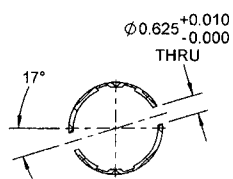
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A5-7 AE



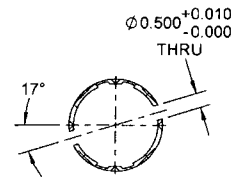
DETAIL AC
SCALE 2X
D3-7
A3-7 AF



SECTION AD-AD
SCALE 3X, 17 PL
D3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7



SECTION AF-AF
SCALE 3X, 4 PL
B4-7

RELEASED
06-02-78

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 7 OF 11
APPROVED		TITLE	SCALE
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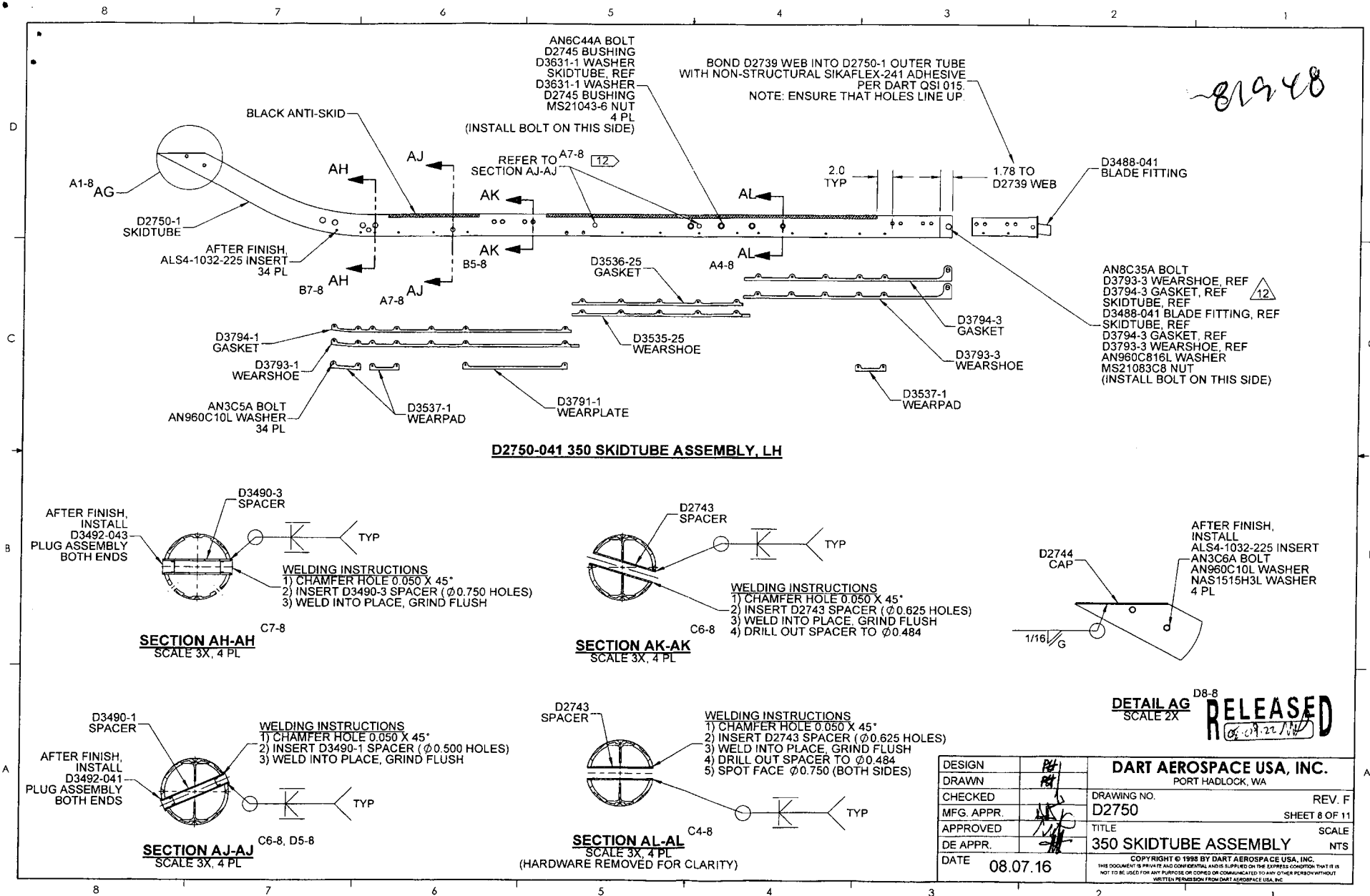
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

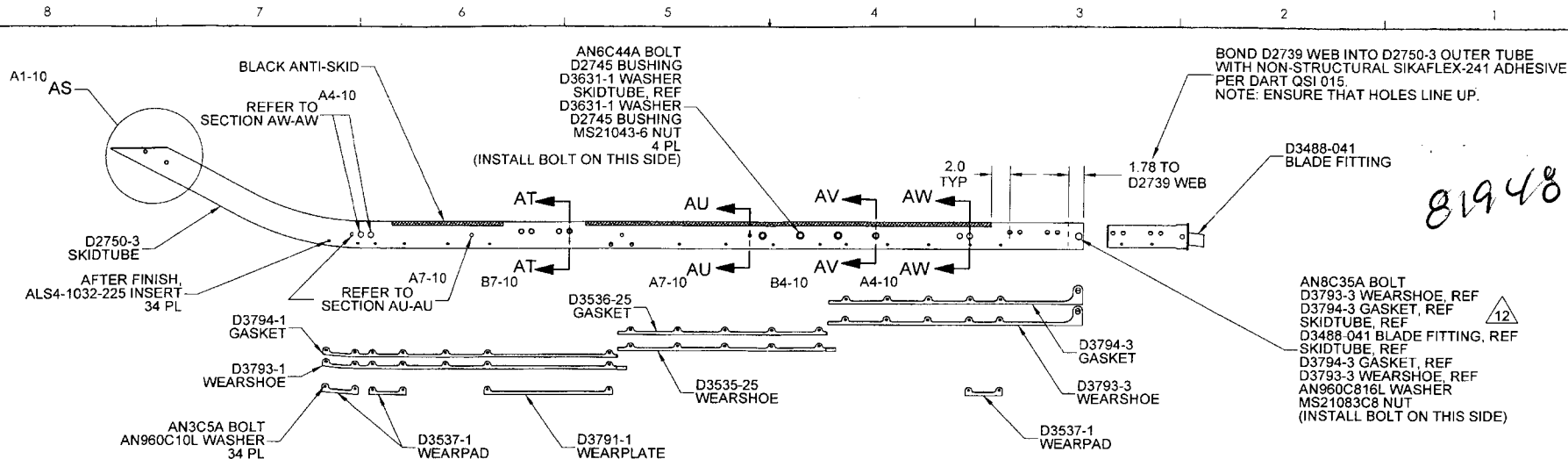
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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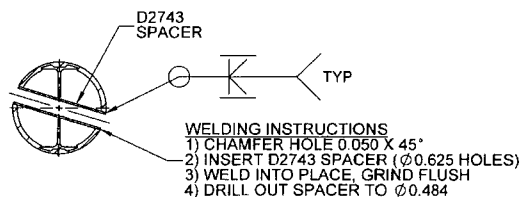
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

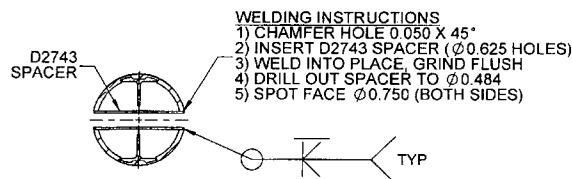
NOTE: Date & initial all entries



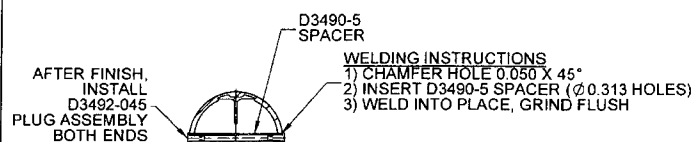
D2750-043 350 SKIDTUBE ASSEMBLY, LH



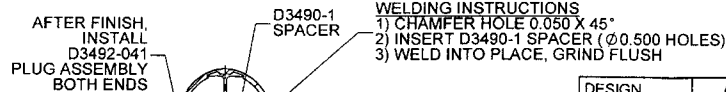
SECTION AT-AT SCALE 3X, 4 PL



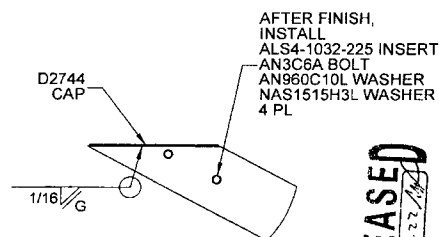
SECTION AV-AV SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU SCALE 3X, 4 PL



SECTION AW-AW SCALE 3X, 4 PL



DETAIL AS SCALE 2X

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	<i>RF</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	<i>AK</i>	D2750	SHEET 10 OF 11
APPROVED	<i>AK</i>	TITLE	SCALE
DE APPR.	<i>AK</i>	350 SKIDTUBE ASSEMBLY	NTS
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28-04-22/16

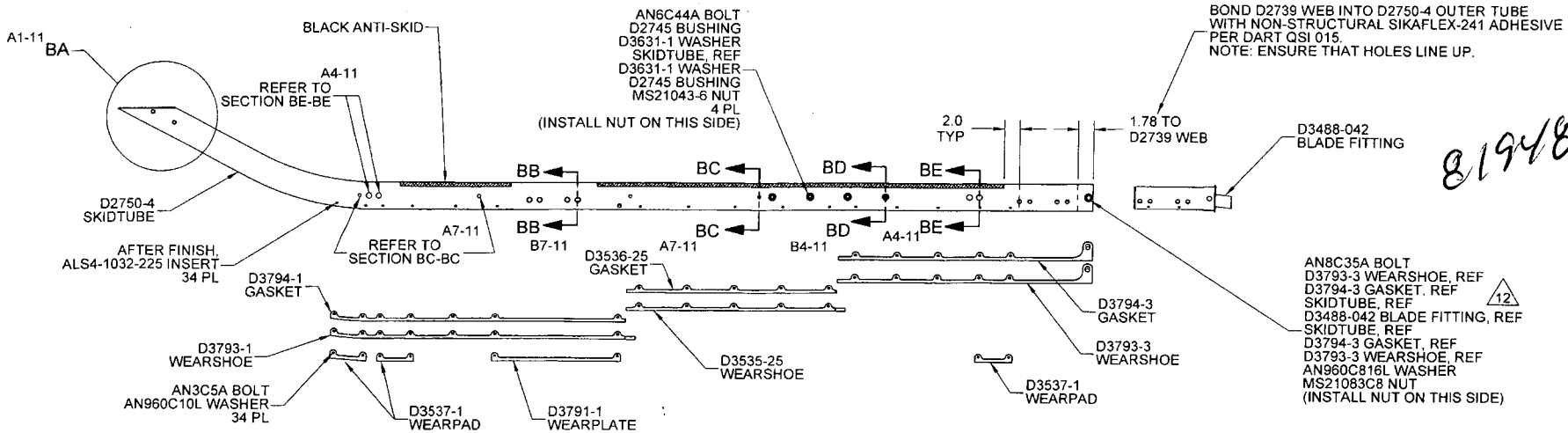
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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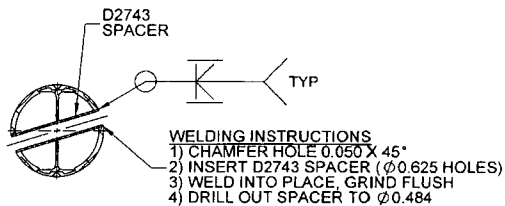
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

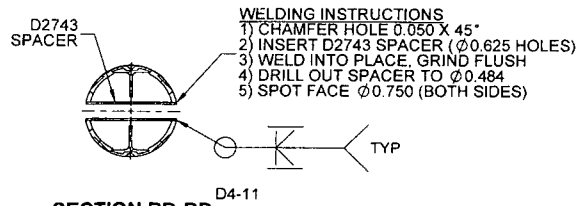
NOTE: Date & initial all entries



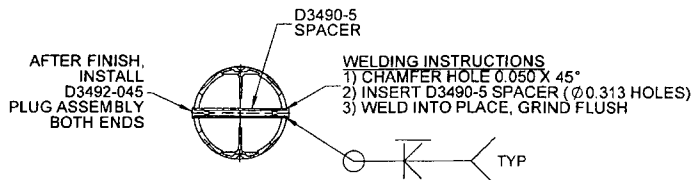
D2750-044 350 SKIDTUBE ASSEMBLY, RH



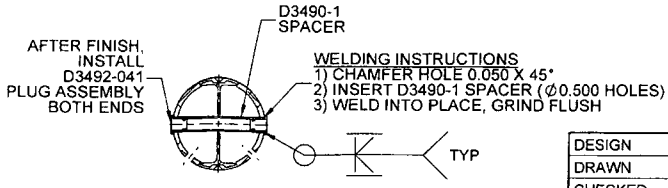
SECTION BB-BB
SCALE 3X, 4 PL



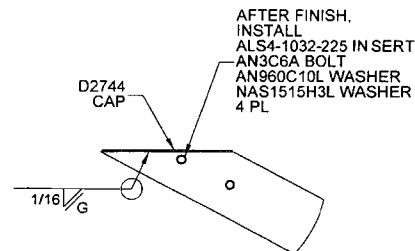
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN	HA	DART AEROSPACE USA, INC.	
DRAWN	HA	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. F
MFG. APPR.	HA	D2750	SHEET 11 OF 11
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 286

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 82189
Part number: A350-006-012
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum.
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Fured Date of Test Coupon 12.04.03
Welder Barclay Elliott Date of Test Coupon 12-04-03

The above named individual is qualified in accordance with AWS D17.1.2001 to weld